

Work Order ID 129453

Tuesday, February 10, 2015 7:05:28 AM

129453

Page 1

Item ID: D5152-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Post Mount Assembly

Start Date: 2/10/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/10/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *1502+10* Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5152

per B

110

Weld per dwg A/R S.S. rod Batch *1423823*

0.00

110

Large Fab

Memo

0.00

Large Fab

6 EL 15-2-26

120

QC9- Inspect visual per QS1004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

(6) 15-02-27

*DAS
9
8-89*

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

6 15-02-27

*DAS
9
8-89*

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Page 2

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Process Plan:

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Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

140

SprayPaint

Memo

0.00

Spray Painting

Prime as per dwg and QSI005 4.2

Batch: 130128

6

DAS
41
9-89

15-2-27

150

0.00

QC14- Inspect Spray Paint

150

QC

Memo

0.00

Quality Control

6

15/02/27

DAS
51
9-89

160

0.00

Identify as per dwg & Stock Location:

L654

160

Packaging

Memo

0.00

Packaging

6

DAS
41
9-89

15-2-27

Work Order ID 129453

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129453

Page 3

Item ID: D5152-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Post Mount Assembly

Start Date: 2/10/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/10/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MW 15-03-03

15.3.3

Picklist Print

Tuesday, February 10, 2015 7:05:33 AM

Page 1

Work Order ID: 129453

129453

Parent Item: D5152-043

D5152-043

Parent Item Name: Aft Post Mount Assembly

Start Date: 2/10/2015

Required Date: 2/10/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 15.01.09 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D5152-3

Manufactured No

Each 1.0000

4

D5152-3

**

EL 15-7-26

Aft Post Mount

12963246

Location

Loc Qty

Loc Code

prelim

1

124086

1

D5152-7

Manufactured No

Each 0.0000

4

D5152-7

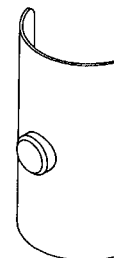
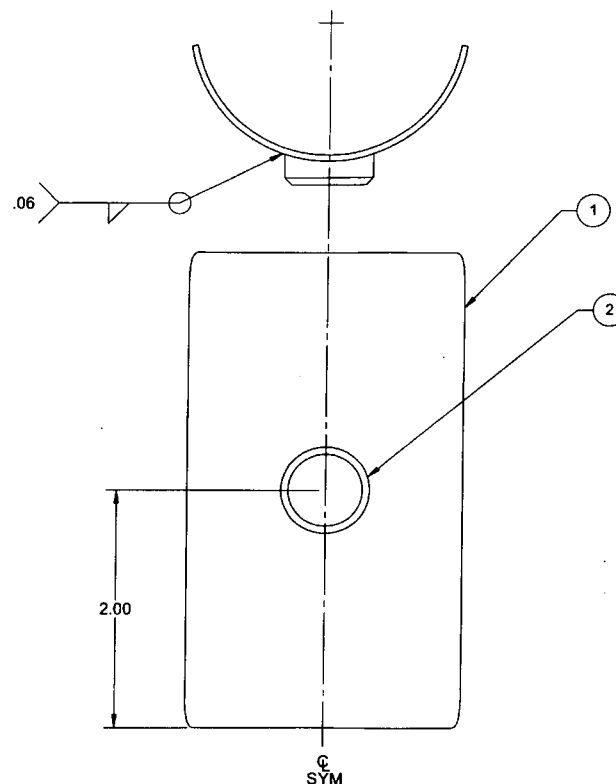
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EL 15-7-26

Aft Step Post

12963046

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5152-041	FWD POST MOUNT ASSY
1	1	D5152-1	FWD POST MOUNT
2	1	D5152-5	FWD STEP POST



D5152-041 FWD POST MOUNT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: D5152-041= 0.21 lbs

WORK COPY
RETURN TO
DESIGN
WORK COPY
ASSEMBLY
OFFICE
FOR ORDER

129453 MLJ
1502-10

RELEASED

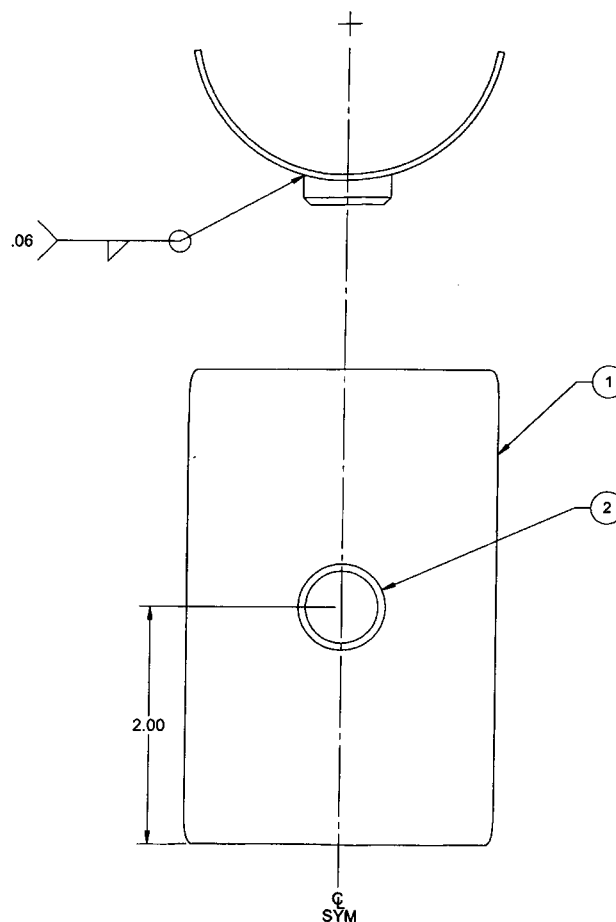
2015 FEB 09

ECN 15-516 4P

B	COMPLETE REDESIGN, SEE PREVIOUS REV FOR DETAILS	DB	15.01.09
A	NEW ISSUE	DB	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	POST MOUNT	NTS
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APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
	X	D5152-043	AFT POST MOUNT ASSY
1	1	D5152-3	AFT POST MOUNT
2	1	D5152-7	AFT STEP POST



D5152-043 AFT POST MOUNT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: D5152-043= 0.23 lbs

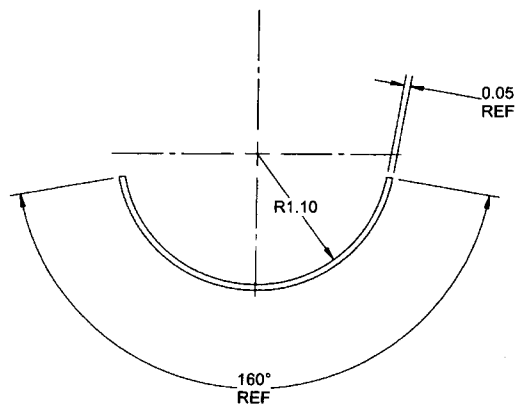
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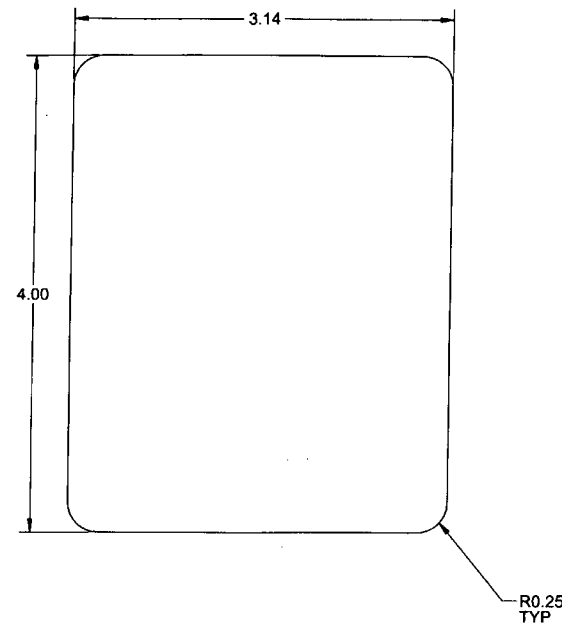
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8 7 6 5 4 3 2 1



D5152-1 FWD POST MOUNT
(MAKE FROM D5152-1F)



D5152-1F FWD POST MOUNT
(FLAT PATTERN)

RELEASED

2015 FEB 09

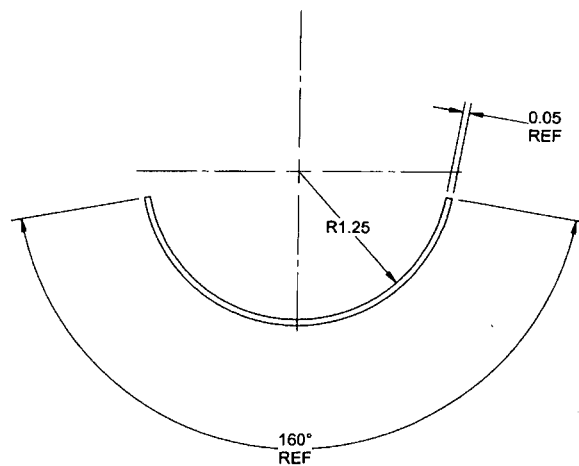
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 0.050" THICK (PER DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

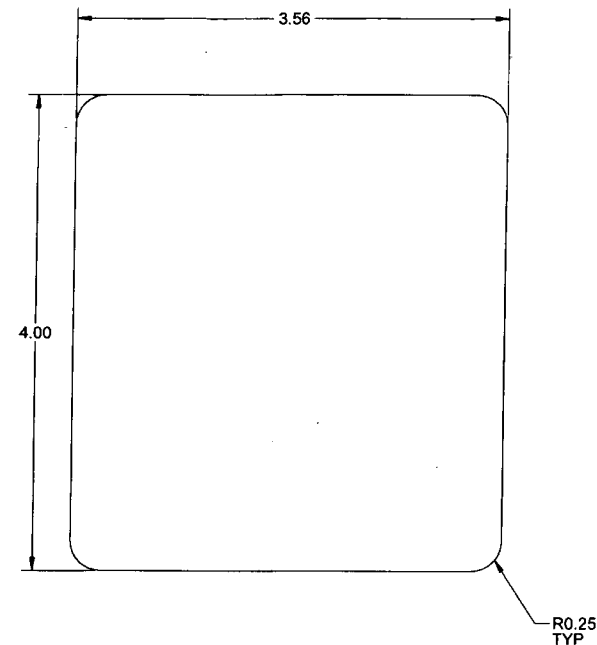
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CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 3 OF 5
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8 7 6 5 4 3 2 1



D5152-3 AFT POST MOUNT
(MAKE FROM D5152-3F)



D5152-3F AFT POST MOUNT
(FLAT PATTERN)

RELEASED

2015 FEB 09

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 0.050" THICK (PER DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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8 7 6 5 4 3 2 1

D

C

B

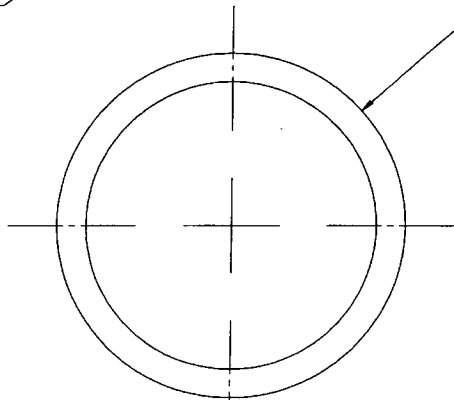
A

R1.150

0.20

0.06 X 45° CMF

Ø0.725



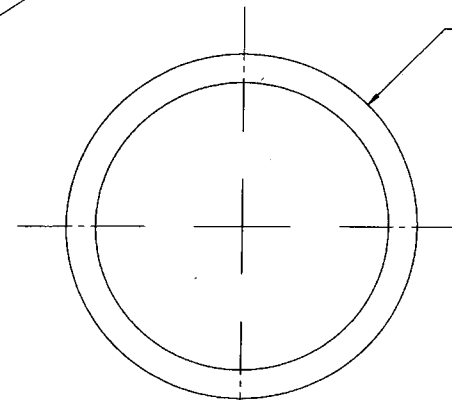
D5152-5 FWD STEP POST

R1.300

0.20

0.06 X 45° CMF

Ø0.725



D5152-7 AFT STEP POST

RELEASED

2015 FEB 09

NOTES:

- 1) MATERIAL: AISI 304/316 SS ROUND BAR PER ASTM A276, REF DART SPEC M304R0.750
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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8 7 6 5 4 3 2 1